

Work Order ID 52493

September 26, 2009 11:32:54 AM



Page 1

Item ID: PB67-43001-261 ^{DA}
 Revision ID: ^{AC} per ECU 09 675
 Item Name: Lever Arm

Accept



Setup Start



Stop



Start Date: 09/28/2009 Start Qty: 12.00
 Required Date: 10/02/2009 Req'd Qty: 12.00



Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: mf Date: 09-09-29 Tooling:
 QC: Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100 0.00



FLOW WATER JET

Waterjet

Memo 0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001 ☐ Dwg Rev: C ☐ Prog Rev: C 12-
 Deburr if necessary

1B 9-9-29

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo 0.00

Quality Control

1B 9-9-29

120 0.00



QC8- Inspect parts - second check

QC

Memo 0.00

Quality Control

27 509/01/09

412

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: PB67-43001-261

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Revision ID: B1

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Start Date: 09/28/2009 Start Qty: 12.00

Required Date: 10/02/2009 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

0.00

0.00

140

Powdercoat

0.00

Powdercoat

Memo

0.00

Powder Coating

Powder Coat (Ref: 4.3.5) as per QSI 005 4.3.5 START TIME: 9:15 AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:45 AM

Hand Finishing

0.00

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

0.00

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Item Name: Lever Arm

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Stop

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Required Date: 10/02/2009 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/10/12

12050

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/05

MF 09-10-03

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

September 26, 2009 11:32:53 AM

Page 1

Work Order ID: 52493

Parent Item: PB67-43001-261RevB1

Parent Item Name: Lever Arm

Start Date: 09/28/2009

Required Date: 10/02/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.250X06.00 0		Purchased	No			100	f	28.8000	17.5326			



6061-T6 Bar .250 x 6.00



B 9-9-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

28.8

108462

2

10925

3

110913

23.8

110913

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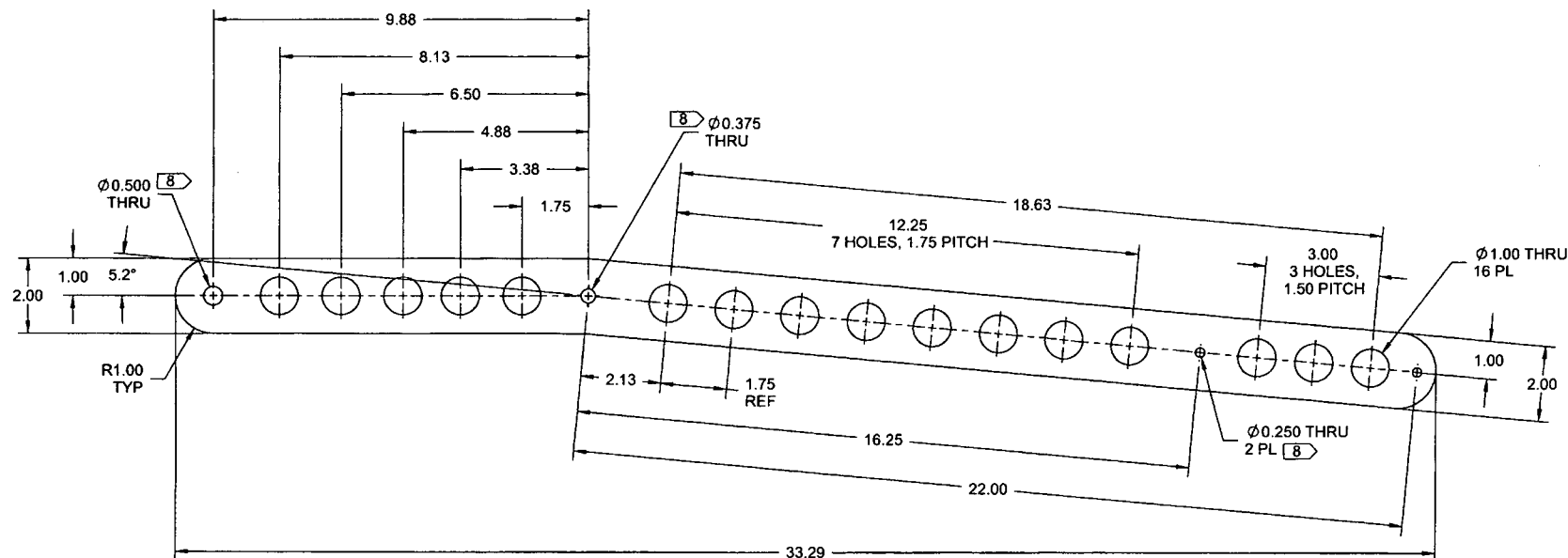
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B67-43001-261 LEVER ARM

RELEASED
2009-09-24
MD

#52493

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs
- 8) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 39 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF 1	
DRAWN				
CHECKED		DRAWING NO. B67-43001-261	SCALE NTS	
MFG. APPR.		TITLE LEVER ARM		
APPROVED				
DE APPR.	N/A			
DATE	09.03.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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